

Date: Tuesday, 3/20/2007 12:04:15 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PLATE		
Job Number	: 31343						
Estimate Number	: 10425						
P.O. Number	:			Part Number	: D32191		
This Issue	: 3/20/2007	S.O. No.	:	Drawing Number	: D3219 REV A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: A		
Previous Run	: 30562			Material	:		
Written By	:			Due Date	: 4/5/2007		
Checked & Approved By	: <u>John J. O'Brien</u>			Qty:	40	Um:	Each
Comment	: Est. A 04.04.19 New issue KJ/JLM						
	: ESR B 06.05.25 Waterjet EC						

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6S125	6061-T6 .125 Sheet	
		Comment: Qty.: 0.1012 sf(s)/Unit Total: 4.0488 sf(s) 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: <u>H103156</u>	
material remaining	3 x 2 ft	SAD 07/06/05	42
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		SAD 07/06/05	42
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/06/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLATE

Job Number: 31343

Part Number: D32191

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/07

(42)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA5

AC. 07.06.07

(42)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



07.06.13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31343
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	SG	Prototype Approval:	N/A
Date:	07/06/05	Date:	07-06-05	Date:	N/A

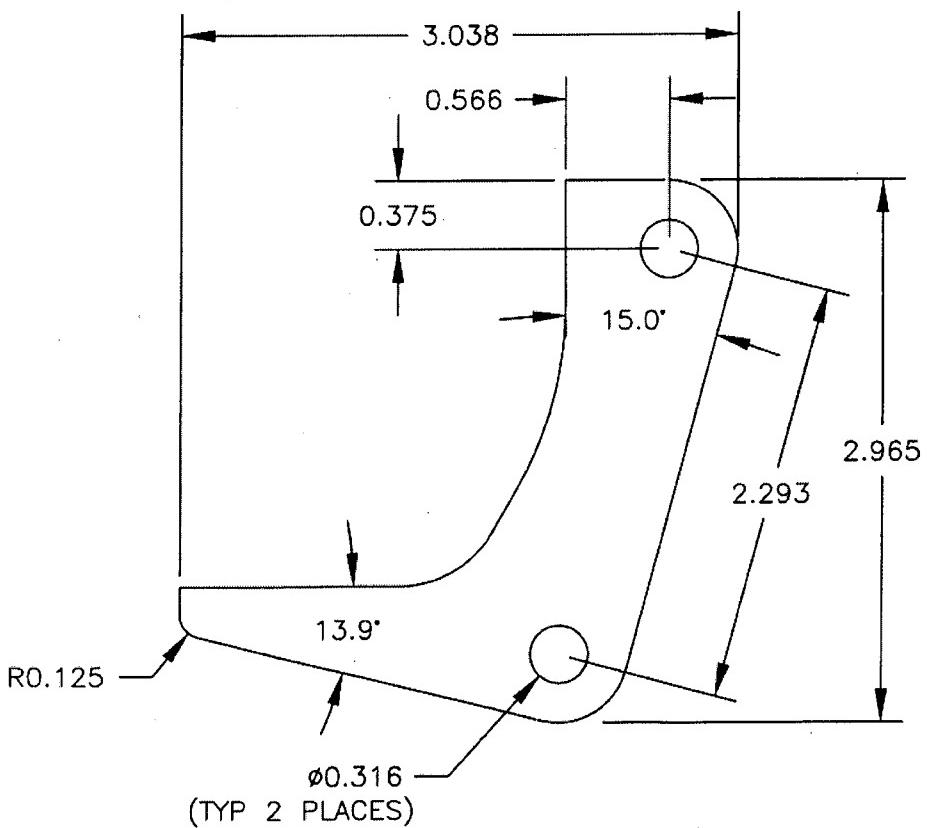
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	JL

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3219	SHEET 1 OF 1
DATE	TITLE	SCALE	
03.10.10	PLATE	1:1	
A	03.10.10	NEW ISSUE	

RELEASED

04.04.05

D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31343

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